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D3167-1

Job Sheet 215874



Part No: D3167-1

Job Qty: 6 pcs

DAS
21
9-89

Part Name: Bearpaw



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/24/20

Job Tracking No:

Due Date: 1/15/21

Created By: Marie Lajeunesse

Type: ~~Stock~~ *Sold*

Description:

Note: DWG REV A1

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	Waterjet - Flow - 1	6 pcs	1/14/21	1/14/21	0.17	2.03	Waterjet - Flow		<i>on 20/12/04</i>
130	HAAS 4 Axis - B4B	6 pcs	1/15/21	1/15/21	1.00	9.84	HAAS - 1 - B4B		DAS 52 9-89 <i>20/12/10</i>
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
140	QC 2	6 pcs	1/15/21	1/15/21	0.00	0.00	QC 2 - 1		DAS 52 9-89 <i>20/12/10</i>
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		

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				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
150	QC 8	6 pcs	1/15/21	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
					QC 8 - 61
					QC 8 - 66
					QC 8 - 73
					QC 8 - 82
151	Packaging 3-1 - Stock - B4B	0 pcs	1/15/21	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B ✓
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B

m/20/12/11

12 pcs

 DAS
 DEC 11 2020 80
 ST454 9-89

				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
190 QC 21 - SA	6 pcs	1/15/21	0.00 0.00	QC 21 - SA - 21	DAS 21 9-89 DEC 11 2020
				QC 21 - SA - 70	
				QC 21 - SA - 9	
				QC 21 - SA - 77	
				QC 21 - SA - 28	

Part Op 120 - Cut Blank as per File D3167-1_BLANK
 Descriptions: 130 - (HAAS CNC Vertical Machine) Note: (2) Bearpaw for (1) Kit 2-Machine as per Folio FA285 and Dwg D3167
 140 - (QC2- Inspect parts off machine FAI/FAIB)
 150 - (QC8- Inspect parts - second check)
 151 - (Identify as per dwg & Stock Location: _____)
 190 - (QC21- Final Inspection - Work Order Release)

Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	216000 sf (3.6 ea)	120-Waterjet - Flow - 1		3262/28
		10 4.2			
		9-89			

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
120-Waterjet - Flow - 1	MUHMWB10	22	401	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bearpaw	0.060inches + 0.030 - 0.010	0.090 0.050	0.060	
2	Bearpaw	45.000Degrees ± 0.500	45.500 44.500	45°	
3	Bearpaw	5.800inches ± 0.030	5.830 5.770	5.800	
4	Bearpaw	0.250inches ± 0.030	0.280 0.220	0.250	
5	Bearpaw	45.000Degrees ± 0.500	45.500 44.500	45°	
6	Bearpaw	0.250inches ± 0.030	0.280 0.220	0.250	Radius
7	Bearpaw	0.200inches ± 0.030	0.230 0.170	0.200	
8	Bearpaw	0.250inches ± 0.010	0.260 0.240	0.250	
9	Bearpaw	0.625inches ± 0.030	0.655 0.595	0.635	
10	Bearpaw	0.375inches ± 0.010	0.385 0.365	0.385	
11	Bearpaw	0.950inches + 0.030 - 0.010	0.980 0.940	0.960	
12	Bearpaw	3.210inches ± 0.030	3.240 3.180	3.210	
13	Bearpaw	19.000inches ± 0.030	19.030 18.970	19.00	
14	Bearpaw	0.260inches ± 0.005	0.265 0.255		Diameter 0.260
15	Bearpaw	0.930inches ± 0.030	0.960 0.900		Diameter 0.930
16	Bearpaw	0.300inches + 0.030 - 0.000	0.330 0.300	0.308	
17	Bearpaw	0.375inches ± 0.030	0.405 0.345	0.375	
18	Bearpaw	7.230inches ± 0.030	7.260 7.200	7.230	
19	Bearpaw	4.540inches ± 0.010	4.550 4.530	4.540	
20	Bearpaw	2.000inches ± 0.030	2.030 1.970	2.000	
21	Bearpaw	12.000inches ± 0.010	12.010 11.990	12.000	
22	Bearpaw	6.000inches ± 0.010	6.010 5.990	6.000	
23	Bearpaw	23.750inches ± 0.030	23.780 23.720	23.750	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S318344



Part: D3167-1

Job No: 215874

Serial No/Batch: S318344

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 12/04/20